



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3220-042
Job Sheet 186477



Part No: D3220-042

Job Qty: 4 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-06 JLM IPP: B 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		11/23/18	0.06	0.32	Waterjet - Flow		SC 18/11/20
110	QC	4 pcs		11/23/18	0.00	0.00	QC2 Waterjet-1		SC 18/11/20
120	QC	4 pcs		11/23/18	0.00	0.00	QC8-2		38
130	Small Fab	4 pcs		11/23/18	0.00	0.29	Small Fab-3		9-88 DAS
140	QC	4 pcs		11/23/18	0.00	0.00	QC5		NOV 26 2018 68
150	HandFinish	4 pcs		11/23/18	0.00	0.39	HandFinish1		DR 18/11/20 9-89
160	QC	4 pcs		11/23/18	0.00	0.00	QC3		38
170	Small Fab	4 pcs		11/23/18	0.00	0.29	Small Fab-3		38
180	QC	4 pcs		11/23/18	0.00	0.00	QC5		38
190	Packaging	4 pcs		11/23/18	0.00	0.00	Packaging3-1		NOV 28 2018
200	QC21-SA	4 Ea		11/23/18	0.00	0.00	QC21		NOV 28 2018

Part Op 100 - 1-Cut D3220-2 as per Dwg D3220

Descriptions: 130 - 1-Deburr 2-C'sink D3220-2 as per Dwg D3220

170 - Assemble D3220-042 doubler as per Dwg D3220

DAS
21
9-89 NOV 28 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.7704 sf (.6926 ea)	100-Waterjet - Flow - 1	FM137626
MS20426AD3-3	Rivet	32 Ea (8 ea)	170-Small Fab	5018535
MS21059L4	Nutplate	16 Ea (4 ea)	170-Small Fab	5115613 9x

5118185 7x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	3	37	0
170-Small Fab	MS20426AD3-3	32	3,628	0
	MS21059L4	16	129	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Use-as-is ☐	Thermoforming ☐	Finishing ☐		Other ☐	
		Suspected Unapproved					
Date : _____		Step #: _____					
Description Work Order Deviat							
DART AEROSPACE Container No: S129310 Part: D3220-042 Job No: 186477 Serial No/Batch: S129310 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/20/18 Completed By _____ and / Supervisor _____ val Verification _____ A Coordinator _____ approval _____							
Root Cause							
Environment ☐	No Re-verification ☐	Pressure/Fo ☐	ned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	ue Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not C ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					

DART AEROSPACE LTD		Work Order: 186 477
Description: Doubler		Part Number: D3220-2
Inspection Dwg: D3220	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.498			VSC-01	
14.25	+/-0.030	14.25			Tape	
R0.50	+/-0.030	R0.50				
7.00	+/-0.030	6.999				
7.000	+/-0.005	7.001				
1.50	+/-0.030	1.502				
1.000	+/-0.005	1.001				
0.500	+/-0.005	0.502				
1.000	+/-0.005	1.001				
Ø0.316	+0.006/-0.001	Ø0.320				
Ø0.098	+0.004/-0.001	Ø0.100				
0.050 thick	+/-0.005	0.048				
Grain Direction	N/A	OK				

Measured by: SC	Audited by: DAS 38 9-88	Preliminary Approval:
Date: 18/11/20	Date: NOV 22 2018	Date:

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue P/O D3220-042	KJ/JLM	
B	13.03.07	Dwg Rev updated	KJ	

